

Work Order ID 83537

83537

Page 1

April-19-12 11:23:17 AM

Item ID: D4435-5 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mount Bracket
 Start Date: 19/04/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 03/05/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4435	B					(10)			

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg
 Dwg Rev: B
 Prog Rev: B
 2-Deburr if necessary
 110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control
 120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

B12-5-19
B12-5-19
TLC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83537

83537

Page 3

April-19-12 11:23:17 AM

Item ID: D4435-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mount Bracket
 Start Date: 19/04/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 03/05/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				112	6	11 11/03/29	
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: ST 110 Memo	0.00 0.00				11X		82 12-5-30	
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						12/5/30 MF 12-05-30	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 11:23:21 AM

Page 1

Work Order ID: 83537

83537

Parent Item: D4435-5

D4435-5

Parent Item Name: Mount Bracket

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 11.10.05 NEW ISSUE DD VERF:EC
12.03.06 AS PER DWG REV.B DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	348.0278	0.1732	1.823158			
M6061T6S 040										**			
6061-T6 .040 Sheet													

(11) Z
1812-5-19

Location

Loc Qty

Loc Code

MAT021

348.0278

121030

77.5278

121099

270.5

121030

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

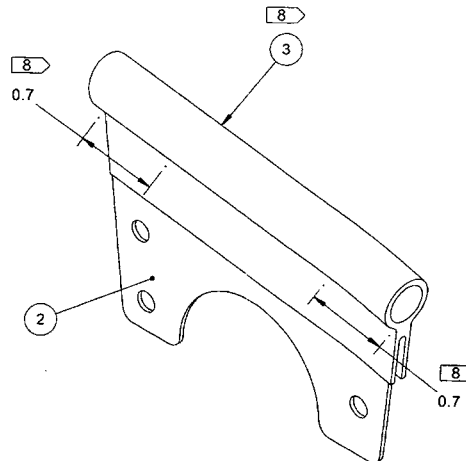
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4435-041	BRACKET ASSEMBLY
2	1	D4435-1	BRACKET
3	1	D4441-1-035	RUBBER SEAL
4	A/R	3M 1300/1300L	ADHESIVE



D4435-041 BRACKET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83531 MLJ
12/04/19

RELEASED
R 2012-03-02
M

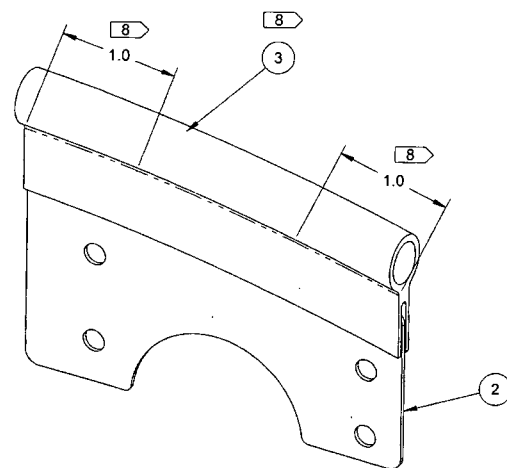
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs
- 8) GLUE RUBBER SEAL TO BRACKET EDGE USING 3M 1300/1300L ADHESIVE, EXCEPT 0.7" FROM EACH END.
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL

B	ADD A HOLE TO D4435-9F (ZN C7-11)	RF	12.01.27
A	NEW ISSUE	RF	12.01.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4435	SHEET 1 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BRACKET	NTS
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ITEM	QTY .043	PART NUMBER	DESCRIPTION
1	X	D4435-043	MOUNT BRACKET ASSEMBLY
2	1	D4435-3	BRACKET
3	1	D4441-1-037	RUBBER SEAL
4	A/R	3M 1300/1300L	ADHESIVE

83537



D4435-043 BRACKET ASSEMBLY

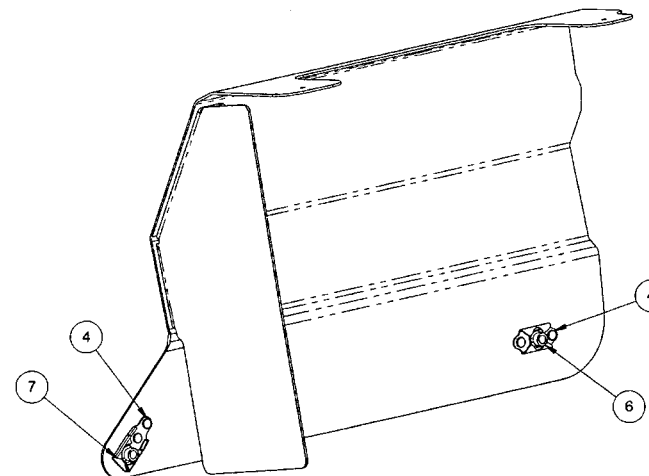
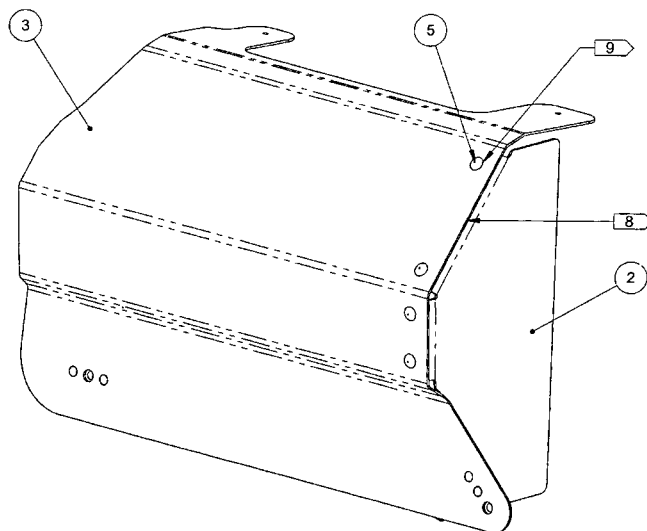
RELEASED
2012-03-03

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs
- 8) GLUE RUBBER SEAL TO BRACKET EDGE USING 3M 1300/1300L ADHESIVE, EXCEPT 1.0" FROM EACH END. ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	BE	D4435	SHEET 2 OF 11
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	BRACKET	NTS
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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	1	D4435-5	MOUNT BRACKET
3	1	D4435-7	BRACKET
4	4	MS20426AD3-2	RIVET
5	4	MS20470AD4-3	RIVET
6	1	MS21059L3	NUT PLATE
7	1	MS21062L3	NUT PLATE



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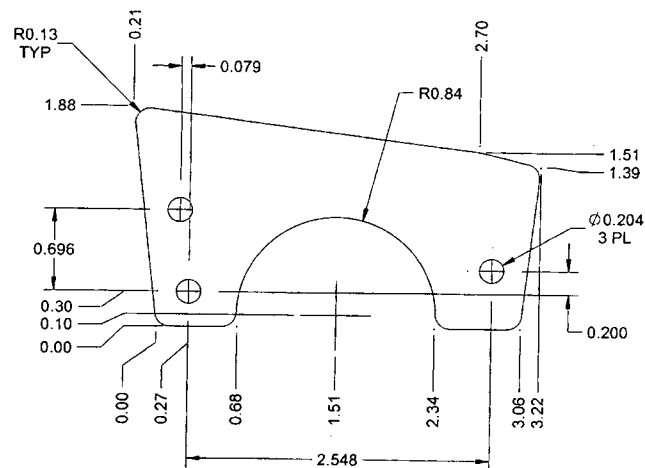
D4435-045 T/R BELLCRANK COVER ASSEMBLY

RELEASED
2012-03-02
JMM

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.371 lbs
- 8) INSTALL D4435-5 BRACKET SURFACE FLUSH WITH THIS EDGE
- 9) TRANSFER $\varnothing 0.129$ HOLES FROM D4435-5 MOUNT BRACKET INTO D4435-7 BRACKET

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	E	D4435	SHEET 3 OF 11
APPROVED	140	TITLE	SCALE
DE APPR.	140	BRACKET	NTS
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D4435-1 BRACKET

NOTES:

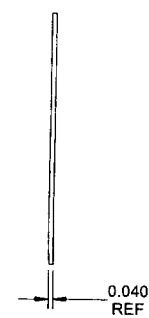
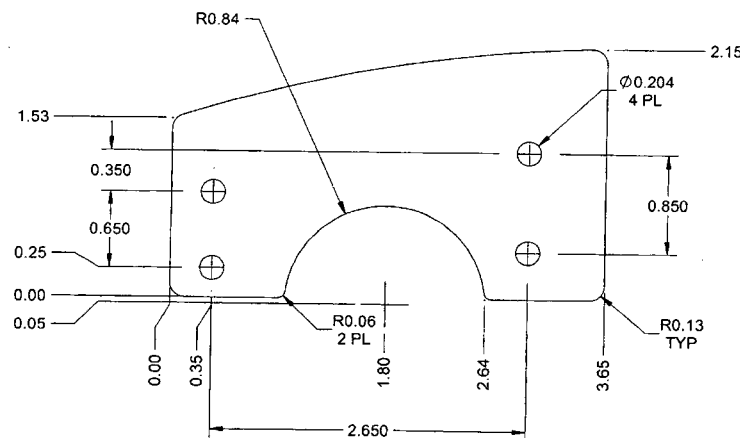
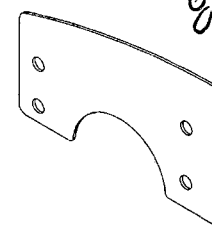
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	140	DRAWING NO. D4435	REV. B
MFG. APPR.	E		SHEET 4 OF 11
APPROVED	140	TITLE BRACKET	SCALE NTS
DE APPR.	140		
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2012-03-02

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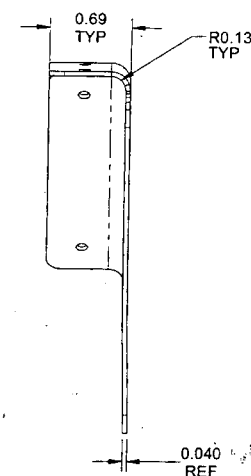
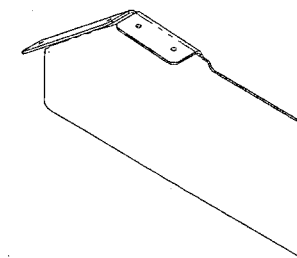
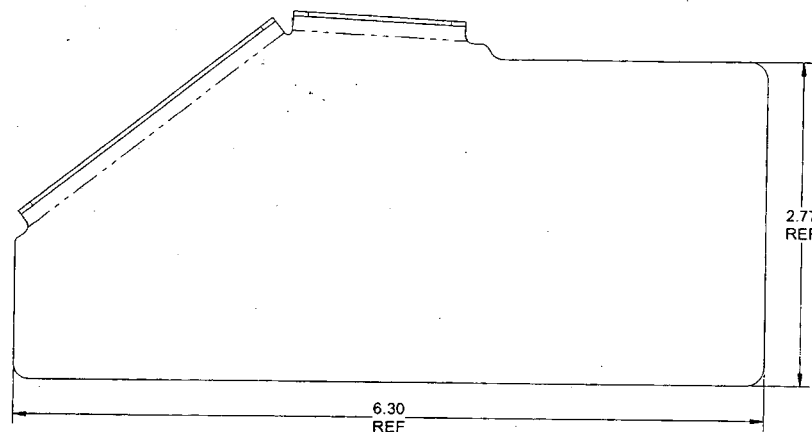


D4435-3 BRACKET

RELEASED
2012-03-02
JMD

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.023 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	140	DRAWING NO. D4435	REV. B
MFG. APPR.	E	SHEET 5 OF 11	
APPROVED	143	TITLE BRACKET	SCALE NTS
DE APPR.			
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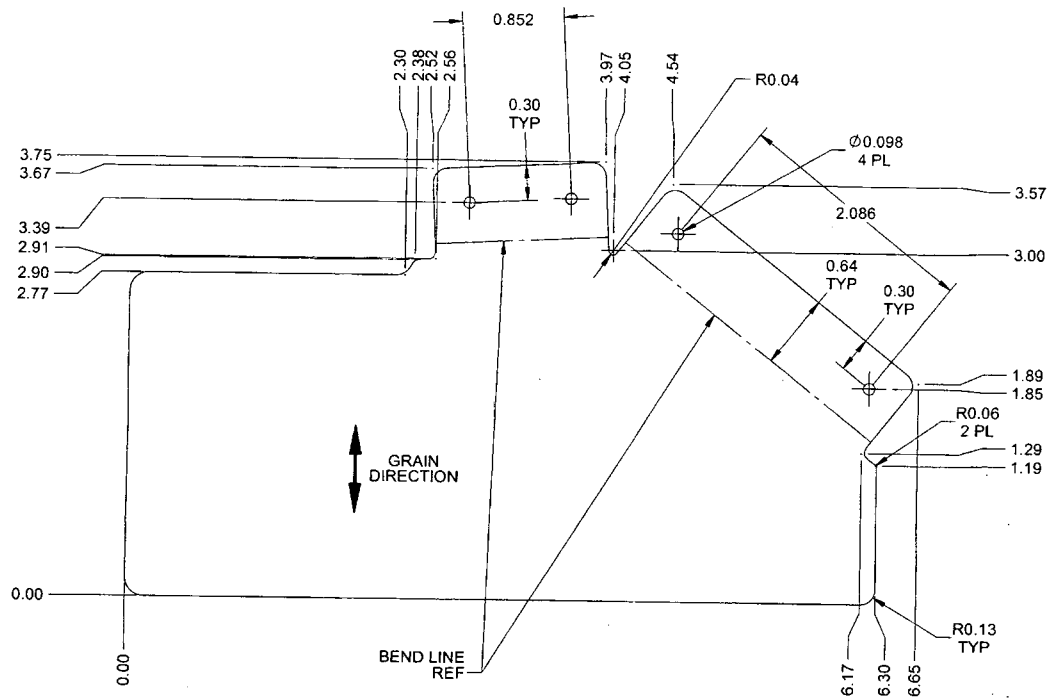
D4435-5 MOUNT BRACKET

RELEASED
2012-03-02

NOTES:

- 1) MATERIAL: MAKE FROM D4435-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	BE	D4435	SHEET 6 OF 11
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	BRACKET	NTS
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D4435-5F FLAT PATTERN

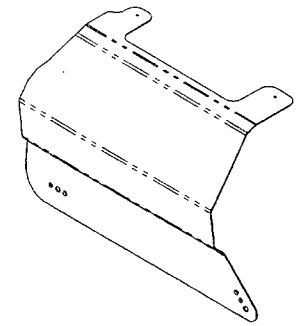
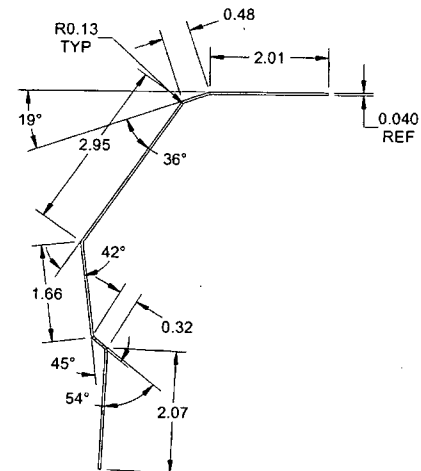
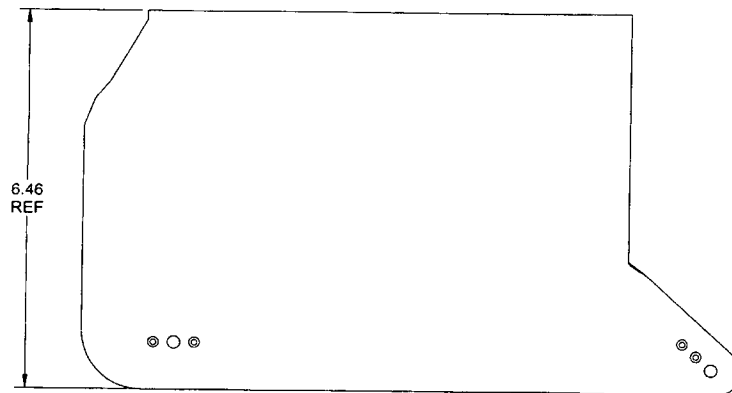
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

RELEASED
2012-03-02
JMD

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	MD	DRAWING NO. D4435	REV. B
MFG. APPR.	BE	SHEET 7 OF 11	
APPROVED	MD	TITLE BRACKET	SCALE NTS
DE APPR.	JH	DATE 12.01.27	

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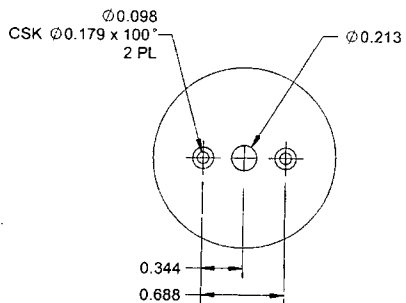
D4435-7 BRACKET

RELEASABLE
2012-03-02

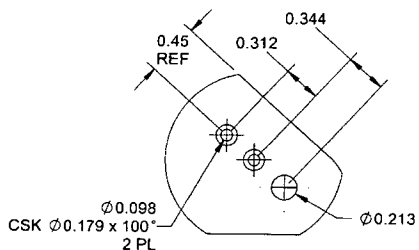
NOTES:

- 1) MATERIAL: MAKE FROM D4435-7F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs

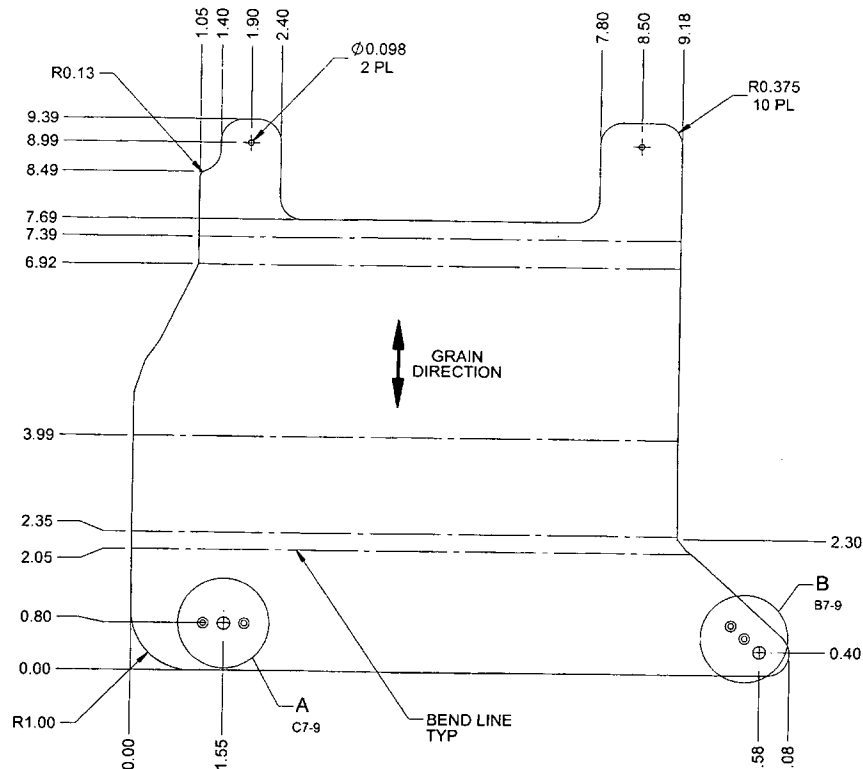
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4435	SHEET 8 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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DETAIL A
SCALE 2X B5-9



DETAIL B
SCALE 2X B3-9



D4435-7F FLAT PATTERN

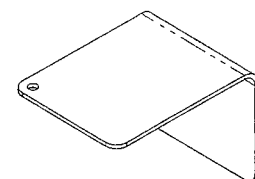
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs

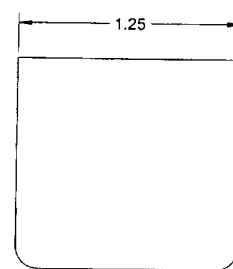
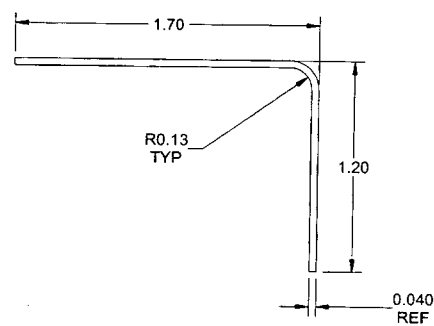
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>140</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>BE</i>	D4435	SHEET 9 OF 11
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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RELEASED
2012-03-02

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D4435-9 BRACKET

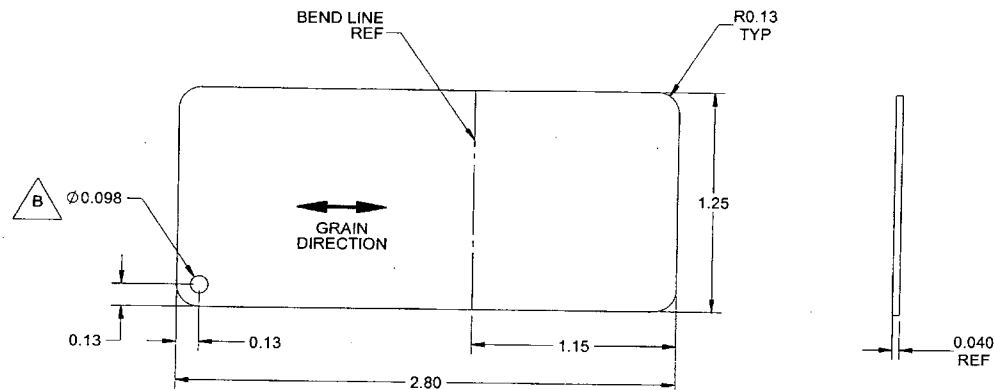
RELEASED
2012-03-02

NOTES:

- 1) MATERIAL: MAKE FROM D4435-9F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	EE	D4435	SHEET 10 OF 11
APPROVED	140	TITLE	SCALE
DE APPR.	140	BRACKET	NTS
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93537



D4435-9F FLAT PATTERN

RELEASE
2012-03-02

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4435	SHEET 11 OF 11
APPROVED	140	TITLE	SCALE
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